

Work Order ID 56617



Page 1

10/2/2010 10:57:30 AM

Item ID: D2694

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod, 350/407

Start Date: 3/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2694

Rev H

I

10-05-11

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

*** QTY of (3) D3001-1 Ship to Delastek ***

Issue P/O:

11446

Description:

D2202-1 Pod Lid

D2202-3 Pod Base

Supplier: Delastek

Copy of Certificate of Conformity and Process sheet from Delastek is required

By 10-3-02

(1)

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure certificate of conformity and process sheet from Delastek is attached

By 10-3-02

Q

Work Order ID 56617

Page 2

March 2, 2010 10:57:37 AM

Item ID: D2694

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod, 350/407

Start Date: 3/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/02/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

S 10/05/16

④

Memo

0.00

Check for void spot and pins. Check over all dimensions as per Dwg D2202.

130



Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Drill hinge, Lid and base as per dwg D2694

81 10 08 25

P40

140



QC

Quality Control

QC6- Inspect dimensions to drawing


0.00

S 10/05/27

④

Memo

0.00

W/O: 56617		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10-08-26	100 25 252	Need hard hard ware (concerning NCR) below <u>D2204-9x2 B 60694</u> <u>2528-1x2 B 52655x1 B57724</u> <u>2528-3x2 B 52656x1 B57728x1</u> <u>AN4-5A x8 B 114330</u> <u>NAS1149D04635x8 B 115107</u> <u>MS21042L4 x8 B 114784</u>	ET	10-08-26		 10-08-26	S 10/08/07	

Part No: D2694 B 56617 PAR #: _____ Fault Category: Small Fals ~~Small Fals.~~ NCR: (Yes) No DQA: / Date: 10-08-07

Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: _____

NCR: 56617		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-08-26	100	ENDS OF POD NOT FLUSH. CORNERS ARE LIFTING. R.C. process design process.	<i>UP</i> 10/08/26 Q5042	INSTALL EXTRA SET OF LATCHES AT EITHER ^{BOTH} ENDS PER DSI 9512. LOCATE 4.75" FROM EDGE	<i>ET</i> 10-08-26	S 10/08/07	<i>UP</i> 10/08/26 Q5042	S 10/08/07

NOTE: Date & initial all entries

Work Order ID 56617



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March 2, 2010 10:57:37 AM

Item ID:	D2694	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Pod, 350/407					
Start Date:	3/02/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/02/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2694 Use DT8023 for (10) holes on base. 2- install placard as per dwg								
160 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170 	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

25 10.08.27

5 10/08/07

(10)

P448/27

PPPS2427

Work Order ID 56617

March 2, 2010 10:57:43 AM



Page 4

Item ID: D2694

Accept



Setup Start



Revision ID:

Stop



Item Name: Pod , 350/407

Start Date: 3/02/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

10/09/02

MF

10-9-02

Picklist Print

March 2, 2010 10:57:26 AM

Page 1

Work Order ID: 56617

Parent Item: D2694

Parent Item Name: Pod, 350/407

Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
IPP F 07.08.21 chg rivet per PAR 185 EC
IPP Rev:G 07-12-10 Rev H dwg DD

Start Date: 3/02/10

Required Date: 4/02/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
--------------------	-------------	------	-----	---------	------	-------	---------	--------	-----------	-----	------	--------

D2258-160

Manufactured

No

150

Each

6.0000

1.0000

Placard

60697 r1



8T 10-08-2F

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

6

32986

6

D3605-1

Manufactured

No

150

Each

5.0000

1.0000

Placard

* Goes in kit



14 6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

52508

5

D3001-1

Manufactured

No

100

Each

13.0000

3.0000

Doubler



52508

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST178

13

52349

13

D2202-1P

Purchased

No

110

Each

0.0000

1.0000

Side Pod Lid, 350



12/10/31/19 X3

change for
D2201-1P-
typo or
- P.O. need to pull batch MF 10-9-2 # 56617

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Work Order ID: 56617

Parent Item: D2694

Parent Item Name: Pod, 350/407

Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
IPP F 07.08.21 chg rivet per PAR 185 EC
IPP Rev:G 07-12-10 Rev H dwg DD

Start Date: 3/02/10

Required Date: 4/02/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2202-3P	Purchased		No			110	Each	0.0000	1.0000			
Side Pod Base, 350												
D2204-9	Manufactured		No			150	Each	23.0000	5.0000			
Latch, Rubber												

M60694 x5

BT 10-08-17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	23	
39689	23	

D2569	Manufactured	No				130	Each	10.0000	1.0000			
Hinge												

BT 10-08-17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	10	
54566	10	

D2429-041	Manufactured	No				150	Each	16.0000	1.0000			
Spring Clip Assembly												

X1

BT 10-08-17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST014	16	
36272	16	

X6

March 2, 2010 10:57:27 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March 2, 2010 10:57:27 AM

Work Order ID: 56617



Parent Item: D2694

Parent Item Name: Pod, 350/407

Start Date: 3/02/10

Required Date: 4/02/10

Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
IPP F 07.08.21 chg rivet per PAR 185 EC
IPP Rev:G 07-12-10 Rev H dwg DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2461		Manufactured	No			150	f	741.3322	14.9158			
Seal												

B55054 x 14.9158



RT 10-08-24

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST404

741.3322

48530

741.3322

D2528-1

Manufactured No

150

Each

29.0000

5.0000



Backer Plate



RT 10-08-17

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST017

29

47602

2

52655

27

D2528-3

Manufactured No

150

Each

23.0000

4.0000



Backer Plate



X5

RT 10-08-17

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST017

23

52656

23

X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 56617

Parent Item: D2694

Parent Item Name: Pod, 350/407



Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
IPP F 07.08.21 chg rivet per PAR 185 EC
IPP Rev:G 07-12-10 Rev H dwg DD

Start Date: 3/02/10

Required Date: 4/02/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3007-041		Manufactured	No			150	Each	5.0000	1.0000			
											ET 10-08-17	
Strut												

AD62ABS



rivet

Purchased

No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST272A	5	
53034	5	

150

Each

232.0000

38.0000

M115254 x 38



XI

ET 10-08-17

AN4-5A



Bolt

Purchased

No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	232	
110804	32	
112896	200	

150

Each

88.0000

19.0000

M114330 x 19



ET 10-08-17

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	88	
100089	6	
109061	9	
110844	7	
112933	66	

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Picklist Print

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Page 5

Work Order ID: 56617

Parent Item: D2694

Parent Item Name: Pod, 350/407


Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
 IPP F 07.08.21 chg rivet per PAR 185 EC
 IPP Rev:G 07-12-10 Rev H dwg DD

Start Date: 3/02/10

Required Date: 4/02/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN4-6A		Purchased	No			150	Each	1,424.000	1.0000			
												
Bolt												

ST 10-08-17

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	1424	
112314	24	
112641	100	
112720	100	
112829	300	
112933	300	
113149	600	

x1

AN526C632R7

Purchased

No

150

Each

282.0000

2.0000



Screw

ST 10-08-17

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	282	
112385	282	

x2

Picklist Print

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Work Order ID: 56617

Parent Item: D2694

Parent Item Name: Pod, 350/407

Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
 IPP F 07.08.21 chg rivet per PAR 185 EC
 IPP Rev:G 07-12-10 Rev H dwg DD

Start Date: 3/02/10

Required Date: 4/02/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD6		Purchased	No			150	Each	1,234.000	2.0000			
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1234

104537 933

6085 301

MA 1149 DO 4635 order QSE 17

AN960JD416

Purchased

No

150

Each

0.0000

21.0000



Washer

MS21042L4

Purchased

No

150

Each

1,905.000

20.0000



Nut

M 115000 x 21

M 114784 x 20

x2

RT 10-08-17

RT 10-08-17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1905

102552 6

104248 6

110507 184

111827 715

113422 994

15924 0

March 2, 2010 10:57:28 AM

Shop Packet Print

Page 6

Picklist Print

March 2, 2010 10:57:29 AM

Page 7

Work Order ID: 56617



Parent Item: D2694



Parent Item Name: Pod , 350/407

Start Date: 3/02/10

Required Date: 4/02/10

Comments: IPP E 03.04.22 Reformat; Modify steps 2,3,4,5 RF
 IPP F 07.08.21 chg rivet per PAR 185 EC
 IPP Rev:G 07-12-10 Rev H dwg DD

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21042L06		Purchased	No			150	Each	172.0000	2.0000			
Nut												

W114494 x2

RT 10-08-17

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	172	
109167	2	
110123	9	
110731	14	
111548	1	
112433	46	
112465	100	

Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2461-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
 - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
 - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
 - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

RELEASED
2010-04-29

I	REFORMAT, D2204-9 LOC SPEC'D (B2-4,B6-4,C2-4,C6-4,B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DEO9119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. I D2694 SHEET 1 OF 5 TITLE SCALE UTILITY POD ASSEMBLY NTS COPYRIGHT © 1987 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	JP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.20		

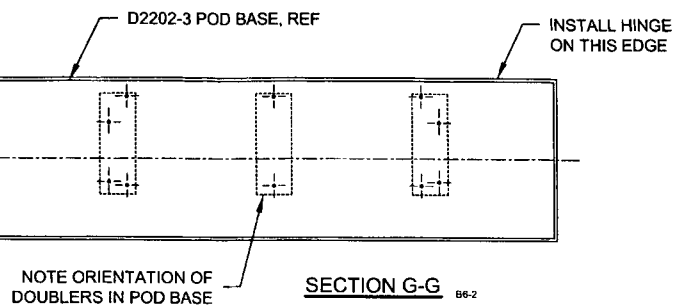
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

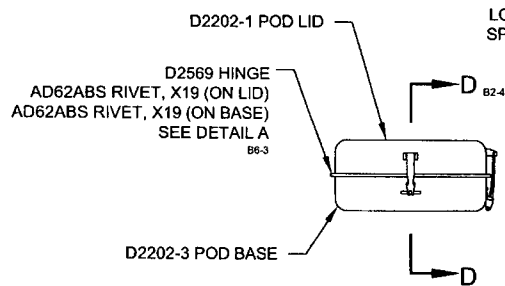
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

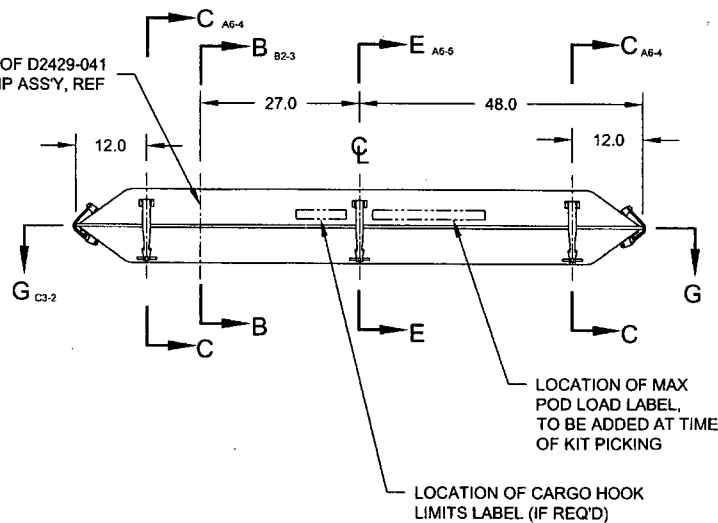
NOTE: Date & initial all entries



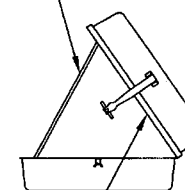
#56617



LOCATION OF D2429-041
SPRING CLIP ASSY, REF



D3007-041 PROP ASSY,
SEE SECTION E & F A6-5, B5-5



D2461-1700 NEOPRENE SEAL,
INSTALL ALONG TOP INSIDE EDGE OF
LID (USE CONTACT CEMENT)



D2694 UTILITY POD ASSEMBLY

RELEASED
2010-04-29

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D2694	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

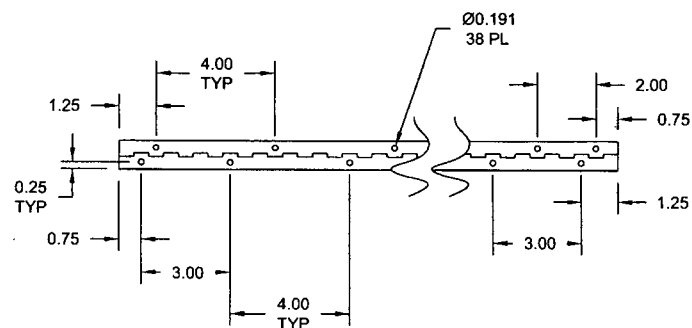
8 7 6 5 4 3 2 1

D

C

B

A



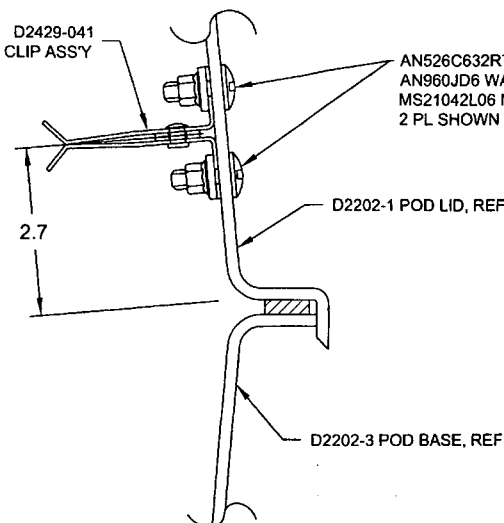
DETAIL A: HINGE
NOT TO SCALE

10
C7-2

D2429-041
SPRING CLIP ASS'Y

AN526C632R7 SCREW
AN960JD6 WASHER
MS21042L06 NUT,
2 PL SHOWN

8



SECTION B-B
NOT TO SCALE

C5-2

RELEASED
2010-04-29
MPO

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

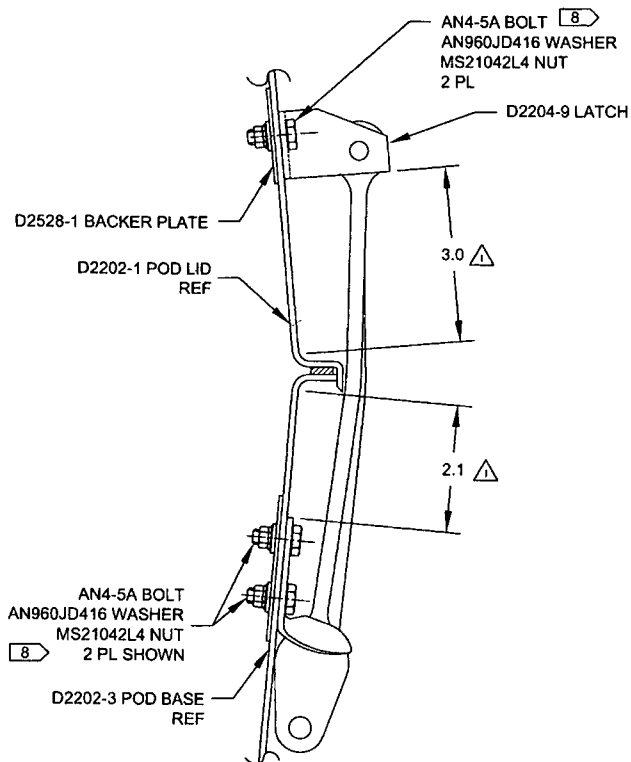
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

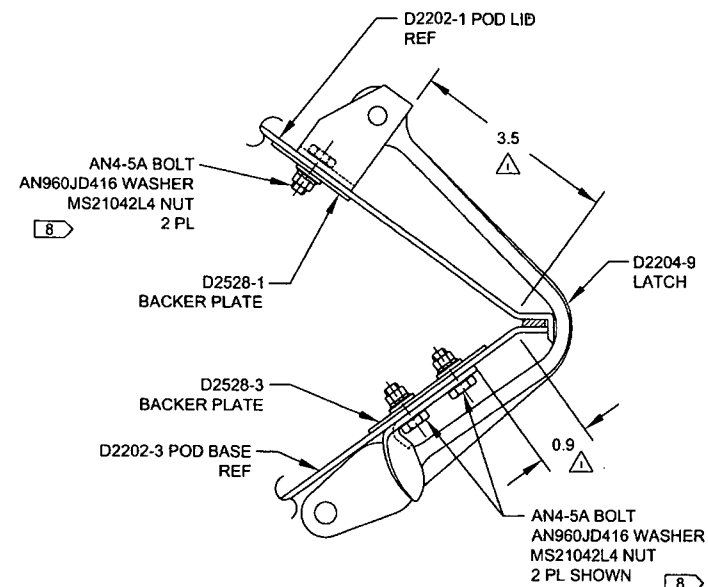
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION C-C C3-2, C5-2
SCALE 10X



SECTION D-D C6-2
SCALE 10X

RELEASED
2010-04-29
JMP

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. 1
MFG. APPR.	JP	D2694	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

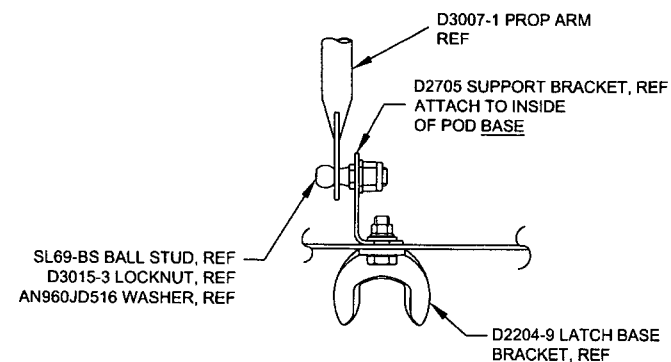
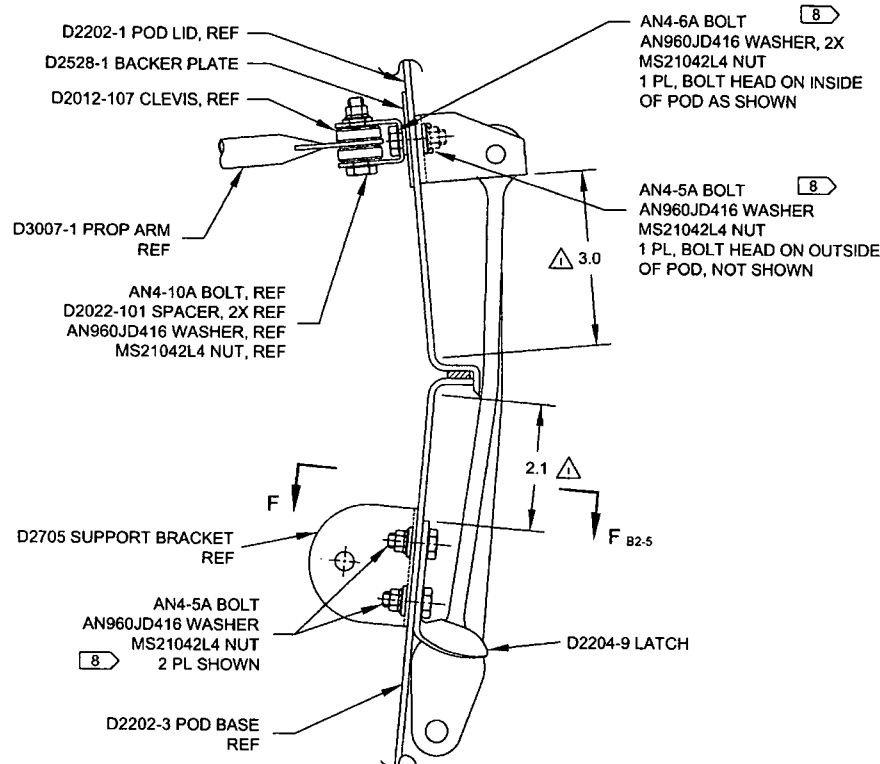
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

#56617



RELEASED
2010-04-28
MP

DESIGN	JB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV.
MFG. APPR.		D2694	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		UTILITY POD ASSEMBLY	NTS
DATE	10.04.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

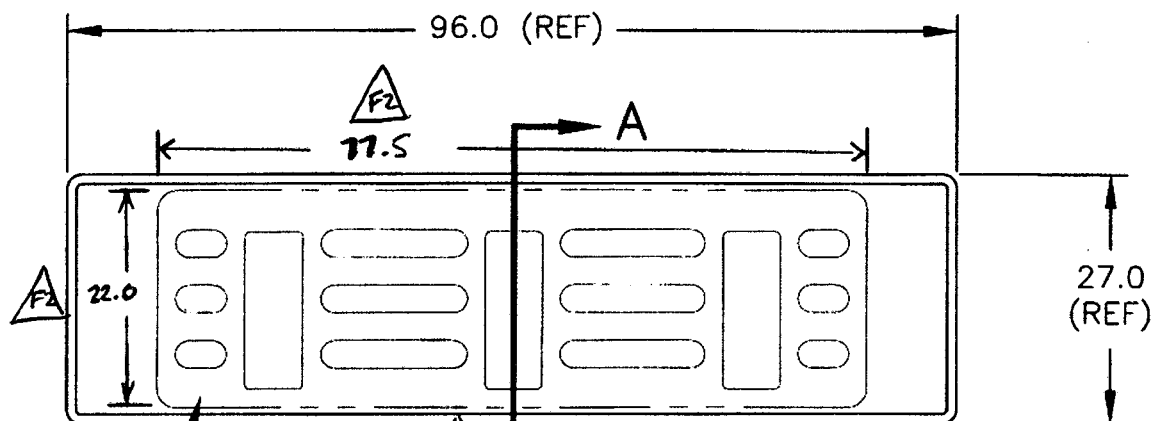
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



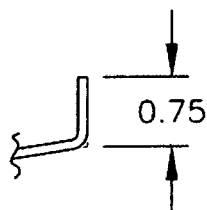
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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D2202	REV. F SHEET 2 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

SEE
DETAIL B

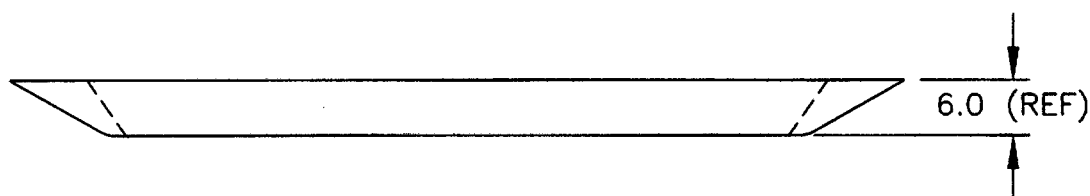


SECTION
A-A

-103 $\triangle F3$
D2202-~~5~~ FOAM CORE,
MAKE FROM 3/8" FOAM, ROUTER PER DT8559



DETAIL B
SCALE 1:2



D2202-3 BASE
(MOLD DT8002)

MAIN LAYUP

9oz SATIN

9oz SATIN

5oz KEVLAR

$\triangle F3$ D2202-103 ~~D2202-5~~ FOAM CORE

5oz KEVLAR

5oz KEVLAR

9oz SATIN

*Reference
only*

RELEASED
01.03.30 *A*

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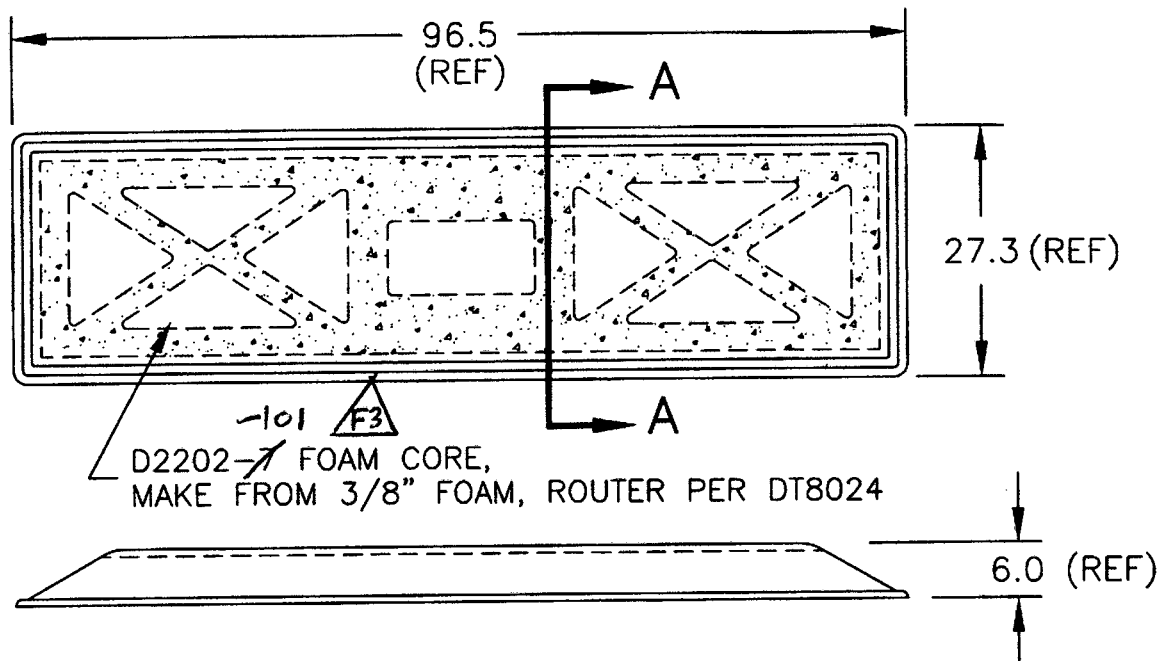
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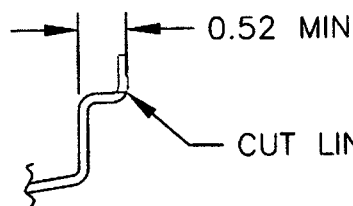
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2202	REV. F SHEET 3 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

SEE
DETAIL B

SECTION
A-A



D2202-1 LID
(MOLD DT8002)



DETAIL B
SCALE 1:2

MAIN LAYUP

9oz SATIN
9oz SATIN
5oz KEVLAR
~~D2202-7~~ FOAM CORE
5oz KEVLAR
9oz SATIN

Reference only

RELEASED
01.03.30 *[Signature]*

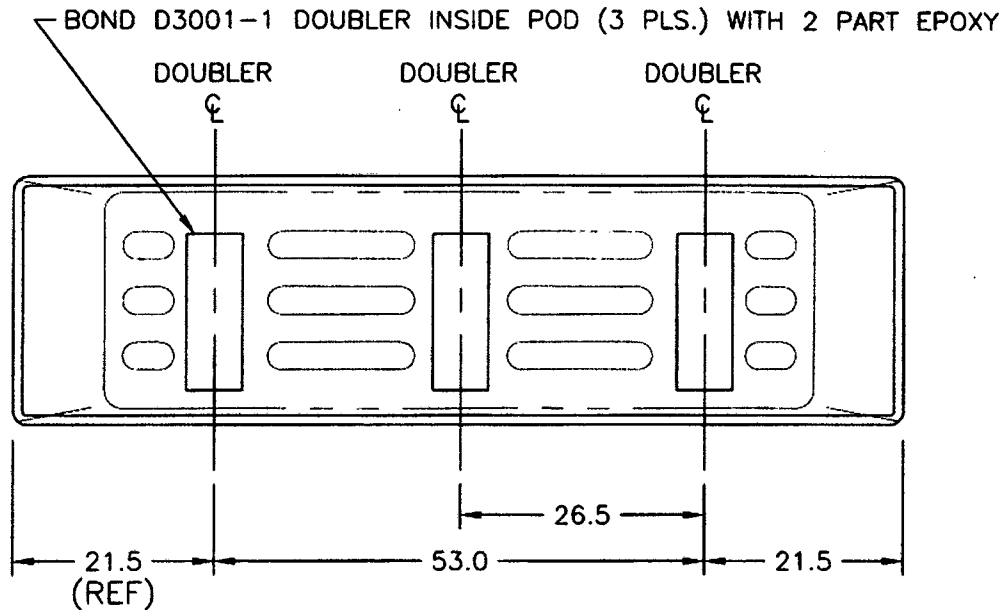
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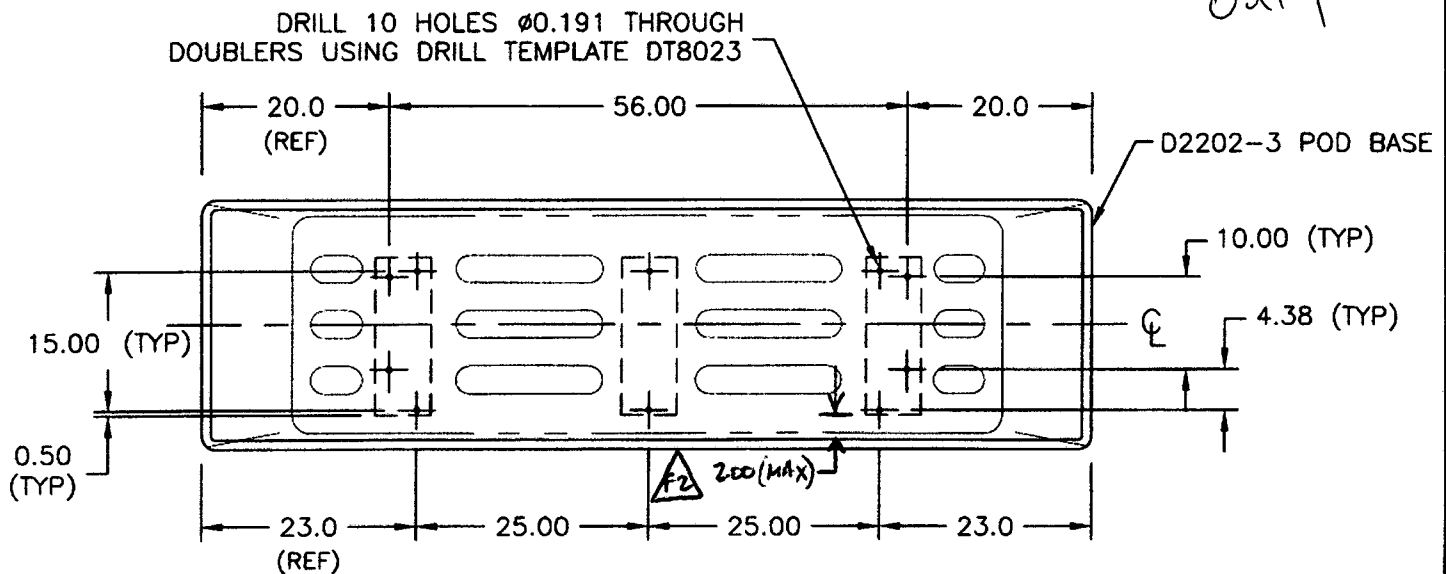
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DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE 1:20

RELEASED
01.03.30



D2202-3 BASE: DOUBLER INSTALLATION

Reference only



D2202-3 BASE: DRILL DETAIL

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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2202	REV. F SHEET 1 OF 4
DATE 01.03.14		TITLE UTILITY POD LID AND BASE	SCALE NTS
A	93.10.27	NEW ISSUE	
B	96.12.16	ADD DOUBLERS AND HOLES	
C	97.07.04	REVISED DOUBLER/HOLE LOCATIONS	
D	98.11.09	MOVED DOUBLERS, REMOVED HOLES	
E	99.11.11	ADDED SECTIONS WITH LIP DIMS	
F	01.03.14	CHANGE LAYUP, DOUBLER, NOW DRILLED	
F1	03.05.08	ADD ALTERNATE FINISH	
F2	03.08.22	CLARIFY FOAM DIMENSION + PLACEMENT.	
F3	04.10.12	CHANGE FOAM PIN PER NCR 798	

RELEASED
01.03.30 *[initials]*

EFFECTIVE	DEOs
Des 9217 REV. A 01.01.26 <i>[initials]</i>	

- 1) LAMINATE PER DART QSI 006.
LAMINATION SCHEDULE PER THIS DRAWING.
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: A500 CORE-CELL, OR DIVINYCELL, OR AIREX, 0.38 THICK (3/8 FOAM)
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS (9oz SATIN)
5 OZ PLAIN WEAVE KEVLAR (5oz KEVLAR)
- 3) PEEL PLY ALL SURFACES.
- 4) FINISH: PRIMER, EPOXY PRIMER WHITE 4500-PB-40
BASE COAT, CHROMATE BASEMAKER 9175S
URETHANE CLEAR COAT, CHROMATE 7500S
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 6) ALL DIMENSIONS ARE IN INCHES.
- 7) ALTERNATE FINISH : INSIDE → DUPONT HIGHBUILD GREY PRIMER 1144-S
OUTSIDE → WHITE GELCOAT # GEL 944WD05

Reference only



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Delastek inc.
2699 5e avenue
Local 14, Porte -A-
Grand-Mère, Québec G9T 5K7
Can ** Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	32909
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Ship to:

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
07/05/2010	02/03/2010	13675	Chantal Lavoie		PO11446		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0014	Line #1 D2202-1 Side Pod Lid B56617 Référence DKA362-0015 DWG: REV. F No. lot 24909 U de M : Each Qté 1			
1	0	1	DKC134-0015	Line #2 D2202-3 Side Pod Base B56617 Référence DKA362-0016 DWG: REV. F No. lot 24910 U de M : Each Qté 1			
							810603/16

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department AQ-357

alt Lundi, 2010-03-15 08:47:36
utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
 Numéro Job : 24909
 Numéro Soumission : 3496
 Numéro B.A. :
 Cette fois : 2010-03-15 No. B.V. :
 rsht Rev. : NC
 rem. fois : - - Type :
 ob précédente : 23901
 crit par :
 éréfié & Approuvé par :
 ommentaires : N° de Pièce Client: D2202-1

Nom Dessin : UTILITY POD LID
 Numéro Article : DKC134-0014
 Numéro Dessin : D2202
 Projet Numéro : DK-362
 Révision dessin : F
 Matériel : Resine Darakane 470-36/411/510
 Date Dûe : 2010-03-22 Qté: 1 UdM: UNITE

DELASTEK
M-2

Process Sheet Rév.: 00 Premier dans DKA à partir de la version 10
 de DKC

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description:

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.30 UNITE(s)/Unit Total: 0.30 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire la préparation du moule N° DT8002 à l'aide de Freekote 44NC selon IG 0009

Quantité: _____ Date: _____ Sceau: _____

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.250 UNITE(s)/Unit Total: 1.250 UNITE(s)

Gel Coat Blanc N° Gel 944W005

N° de Lot:

1-26570-1

1-27127-2

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)

Catalyst N° DDM-9

N° de Lot:

1-22176-1

5.0 AC0747 Acetone

Commentair Qty.: 0.375 KILOGRAMME(s)/Unit Total: 0.375 KILOGRAMME(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10%
 D'acétone.

Quantité: 1 Date: 12-4-10 Sceau:



Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	GEL COAT	Application du Gel Coat
-----	----------	-------------------------



Commentaire Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8002 Selon IG 0019

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 12-4-10 Sceau:

8.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentaire Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26083-1

9.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentaire Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

10.0	AAC1608	5oz plain weave Kevlar 50" wide roll
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Commentaire Qty.: 6.60 VERGE(s)/Unit Total : 6.60 VERGE(s)

5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-6904-1

11.0	AC0884	Wrighton 5200 Bleu P3
------	--------	-----------------------

Commentaire Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

12.0	AC0885	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentaire Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

13.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentaire Qty.: 42.63 VERGE(s)/Unit Total : 42.63 VERGE(s)

14.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentaire Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

15.0	TAILLAGE	Faire le taillage du matériel
------	----------	-------------------------------



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Faire cette opération pour les trois plis de 9 oz ainsi que pour les deux plis de 5 oz de Kevlar.

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):


Peel Ply

Film Durisol P-3

Feutre de drainage 6m

Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Quantité: 1 Date: 19 mars 10 Sceau: 

16.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.500 LITRE(s)/Unit Total: 2.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-26805-2

17.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1



18.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 2% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Quantité: 1 Date: 12-4-10 Sceau:  

19.0 LAMINAGE

Faire le laminage





Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)

Quantité: 1 Date: 12-4-10 Sceau:  

Date: Lundi, 2010-03-15 08:47:36
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



Séq.: Machine ou Opération: Description :



20.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002 selon IG 0012

Laisser sécher jusqu'au lendemain.

Quantité: 1 Date: 12-4-10 Sceau:  

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.400 LITRE(s)/Unit Total : 0.400 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-26805-2

22.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

23.0 DKC134-0022 D2202-101 Foam Core (Utility Pod Lid)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

D2202-101 Foam Core (Utility Pod Lid) N° de Job: 25117

24.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 2% de catalyst DDM-9 par quantité de résine.

Quantité: 1 Date: 26/03/10 Sceau:  



25.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau, appliquer une couche de résine sur toutes les surfaces du Foam Core N° DKC134-0022 selon IG 0105 et positionner le foam Core dans le moule selon le dessin.

Laisser sécher pendant deux heures.

Quantité: 1 Date: 26-03-10 Sceau:  

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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26.0	AAC1611	Polybond B46F
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

Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)
Polybond B46F N° de Lot: 1-7089-1

27.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033

Quantité: 1 Date: 13-7-10 Sceau:  



28.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide sur le moule N° DT8002, assurez vous qu'il n'y aie aucunes pertes de vacuum selon IG 0012

Laisser sécher 1 heure.

Quantité: 1 Date: 13-7-10 Sceau:  

29.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

Commentair Qty.: 2.500 LITRE(s)/Unit Total : 2.500 LITRE(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-27127-1

30.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------



Commentair Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-22176-1

31.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 2% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Quantité: 1 Date: 16-7-10 Sceau:  

32.0	LAMINAGE	Faire le laminage
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Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des deux dernier plis de tissu (1 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes,

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



Séq.:

Machine ou Opération:

Description :

ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour le dernier plis. (un pli de 9 oz)

Quantité: 1

Date: 16-4-10

Sceau:



R.C.

33.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002 selon IG 0012

Laisser sécher jusqu'au lendemain.

Quantité: 1

Date: 16-4-10

Sceau:



R.C.

34.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire le démoulage du Utility Pod Lid en faisant bien attention de ne pas endommager la piece selon IG 0018

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.

Quantité: 1

Date: 20-4-10

Sceau:



35.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot:

1-7129-1

36.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.10 UNITE(s)/Unit Total : 0.10 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot:

37.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air.

Corriger les imperfection de surface à l'aide du Sikkens Polysoft selon IG 0043

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD LID

Numéro Job: 24909

Numéro Article: DKC134-0014

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Laisser sécher jusqu'au lendemain.

Quantité: 1

Date: 20-4-10

Sceau:



38.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le trimage du Pod Lid selon le dessin Page 3 de 4 Détail B

Quantité: 1

Date: 20/04/10

Sceau:



39.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26006-1

40.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26575-5

41.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 75.0000Min Total Run : 1.2500Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Quantité: 1

Date: 23/04/10

Sceau:



42.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

Quantité: 1

Date: 26-4-10

Sceau:



43.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.2167 UNITE(s)/Unit Total : 0.2167 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-26006-1

44.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-26575-5

Date: Lundi, 2010-03-15 08:47:36
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24909

Nom Dessin: UTILITY POD LID
Numéro Article: DKC134-0014

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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45.0	PRIMER	Application primer
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Quantité: 1 Date: 27/04/10 Sceau: 

46.0	INSPEC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 28-4-10 Sceau: 

47.0	EMBALLAGE	Emballage & Entreposage
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1 Date: 28-04-10 Sceau: 

Date: Lundi, 2010-03-15 08:47:38
Marc Dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: UTILITY POD BASE
Numéro Job	: 24910	Numéro Article	: DKC134-0015
Numéro Soumission	: 3497	Numéro Dessin	: D2202
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2010-03-15 No. B.V. :	Révision dessin	: F
Prsht Rev.	: NC	Matériel	: Resine Darakane 470-36/411/510
Prem. fois	: - - Type :	Date Due	: 2010-03-22 Qté: 1 UdM: UNITE
Job précédente	: 24325		
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de Pièce Client: D2202-3		

Process Sheet Rév.: 00 Premier dans DKA à partir de la version 10 de DKC

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AC0085 FREKOTE 3,78L 44-NC

Commentair Qty.: 0.03 UNITE(s)/Unit Total: 0.03 UNITE(s)

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Faire la préparation du moule N° DT8002 à l'aide de Freekote 44NC selon IG 0009

Quantité: / Date: / Sceau: /

3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 0.125 UNITE(s)/Unit Total: 0.125 UNITE(s)

Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-20570-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0095 GALLON(s)/Unit Total: 0.0095 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

5.0 AC0747 Acetone


Commentair Qty.: 0.375 KILOGRAMME(s)/Unit Total: 0.375 KILOGRAMME(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run: 0.1667Hrs

Dans une quantité de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% D'acétone.

Quantité: / Date: 23 mars 10 Sceau: 

Date: Lundi, 2010-03-15 08:47:38
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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7.0	GEL COAT	Application du Gel Coat
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Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

À l'aide d'un fusil à peinture appliquer une couche entre 15 et 20 millièmes de Gel Coat sur le moule N° DT8002 Selon IG 0019

Note: Le gel coat ne doit contenir aucun "airdry" ni aucune cire. Et le temp de séchage est important afin d'éviter d'avoir des défauts de surface, et afin d'éviter que le tissu ne vienne marquer au travers du Gel Coat ainsi que d'éviter d'avoir un rétrécissement.

Quantité: 1 Date: 23 mars 10 Sceau:



8.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
-----	---------	---

Commentair Qty.: 9.9 VERGE(s)/Unit Total : 9.9 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-26083-1

9.0	AAC1608	5oz plain weave Kevlar 50" wide roll
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Commentair Qty.: 9.90 VERGE(s)/Unit Total : 9.90 VERGE(s)

5oz plain weave Kevlar 50" wide roll

N° de Lot: 1-6904-1

10.0	AC0883	Tissu à délaminer Release ply B
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Commentair Qty.: 9.16 VERGE(s)/Unit Total : 9.16 VERGE(s)

11.0	AC0884	Wrightlon 5200 Bleu P3
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Commentair Qty.: 14.95 VERGE(s)/Unit Total : 14.95 VERGE(s)

12.0	AC1091	Film durisol # 3001792
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Commentair Qty.: 12.50 METRE CAR(s)/Unit Total : 12.50 METRE CAR(s)

13.0	AC0885	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 12.50 VERGE(s)/Unit Total : 12.50 VERGE(s)

14.0	AC0943	Stretchlon 200 poche à vide Vert
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Commentair Qty.: 42.63 VERGE(s)/Unit Total : 42.63 VERGE(s)

15.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 3.0000 ROULEAU(s)/Unit Total : 3.0000 ROULEAU(s)

16.0	TAILLAGE	Faire le taillage du matériel
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le taillage du matériel selon les Dimensions requises:

Un morceau pour recouvrir le fond du moule N° DT8002.

Deux morceaux pour couvrir les extrémités du moule N° DT8002.

Deux morceaux pour recouvrir les cotés du moule N° DT8002.

Date: Lundi, 2010-03-15 08:47:38
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



Séq.:

Machine ou Opération:


Description :

Faire cette opération pour les trois plis de 9 oz ainsi que pour les trois plis de 5 oz de Kevlar.

Tailler le matériel nécessaire pour la poche à vide (Faire 3 kits car il y aura trois baggings différents lors de la fabrication de cette pièce):

Peel Ply
Film Durisol P-3
Feutre de drainage 6mm
Stretchlon 200

Coller une bande de ruban jaune tout le tour du Stretchlon 200, plier les différentes composantes des poches à vide et entreposer en attente des opérations de bagging.

Quantité: 1 Date: 8 mars 10 Sceau: 

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.500 LITRE(s)/Unit Total: 2.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-26805-2

18.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0845 GALLON(s)/Unit Total: 0.0845 GALLON(s)



Catalyst N° DDM-9 N° de Lot: 1-22176-1

19.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Mélanger la quantité de résine désirée pour le laminage des trois premier plis du Pod Lid : 2% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 Min.

Quantité: 1 Date: 23-3-10 Sceau:  

20.0 LAMINAGE Faire le laminage





Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des trois premiers plis de tissu (2 plis de 9 oz et 1 pli de 5 oz Kevlar) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 Minutes, ensuite venir laminer un pli de 9 oz dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour les deux autres plis. (un pli de 9 oz et un pli de 5 oz Kevlar)

Quantité: 1 Date: 23-3-10 Sceau:  

Date: Lundi, 2010-03-15 08:47:38
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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21.0	BAGGING	Faire le bagging sur la pièce
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Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002 selon IG 0012

Laisser sécher jusqu'au lendemain.

Quantité: 1 Date: 23-3-10 Sceau:



22.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.400 LITRE(s)/Unit Total : 0.400 LITRE(s)

Résine (411B7530) 411-350 promo. 75min

N° de Lot: 1-26805-2

23.0	AMB0286	Catalyst N° DDM-9
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Commentair Qty.: 0.0135 GALLON(s)/Unit Total : 0.0135 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-22176-1

24.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire un mélange de résine Derakane 411-350 Promoté 15 à 18 Minutes 2% de catalyst DDM-9 par quantité de résine.

Quantité: 1 Date: 26/03/10 Sceau:



25.0	DKC134-0021	D2202-103 Foam Core (Utility pod Base)
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Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

D2202-103 Foam Core (Utility pod Base)

N° de Job: 25116

26.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Sceller le foam core selon IG 0105

Quantité: 1 Date: 26-3-10 Sceau:



27.0	AAC1611	Polybond B46F
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Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s)

Polybond B46F

N° de Lot: 1-7089-1

28.0	ASSEMBLAGE	Assemblage mécanique
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Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'assemblage du Foam Core N° DKC134-0022 à l'aide du polybond 46F selon IG 0033

Date: Lundi, 2010-03-15 08:47:38
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015



Numéro Job:



Séq.:

Machine ou Opération:

Description

Quantité: 1 Date: 29-3-10 Sceau:  

29.0

BAGGING



Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002, assurez vous qu'il n'y aie aucunes pertes de vacuum selon IG 0012

Laisser sécher 1 heure.

Quantité: 1 Date: 29-3-10 Sceau:  

30.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.500 LITRE(s)/Unit Total : 2.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-26805-1

31.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0845 GALLON(s)/Unit Total : 0.0845 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-22176-1

32.0



PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Mélanger la quantité de résine désirée pour le laminage des deux derniers plis du Pod Base: 2% de catalyst DDM-9 par quantité de résine Derakane 411-350 Promoté 75 minutes.

Quantité: 1 Date: 08 avril 10 Sceau:  

33.0

LAMINAGE

Faire le laminage





Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire le laminage des trois derniers plis de tissu (2 plis de 5 oz Kevlar et 1 pli de 9 oz) de la façon suivante:

Recouvrir toute la surface du moule N° DT8002 à l'aide de de résine Derakane 411-350 Promoté 75 minutes, ensuite venir laminer un pli de 5 oz Kevlar dans le fond du moule, suivre avec les deux extrémités et terminer avec les deux cotés. (Ajouter de la résine au besoin)

Recommencer pour les deux autres plis. (un pli de 5 oz Kevlar et un pli de 9 oz)

Quantité: 1 Date: 08 avril 10 Sceau:   R.C. A.M.

Date: Lundi, 2010-03-15 08:47:38
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



Séq.:

Machine ou Opération:

Description :

34.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide sur le moule N° DT8002, selon IG 0012

Laisser sécher jusqu'au lendemain.

Quantité: 1

Date: 08 avril 10

Sceau: 34



AM, RC

35.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire le démoulage du Utility Pod Base en faisant bien attention de ne pas endommager la piece selon IG 0018

Autocontrôle de la qualité du laminage en frappant légèrement sur toute la surface du Pod à l'aide du manche d'un tournevis.

Quantité: 1

Date: 9-4-10

Sceau: 34



36.0

AAC1390

MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

MASTIC POLYSOFT SIKKENS 3AR591

N° de Lot: 1-7129-1

37.0

AAC1617

Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.10 UNITE(s)/Unit Total : 0.10 UNITE(s)

Durcisseur Polysoft #004009 Sikkens

N° de Lot:

38.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Sabler légèrement toute la surface intérieur du pod à l'aide de papier sablé grit 120.

Vérifier la surface intérieur du pod et injecter à l'aide d'une seringue munit d'une aiguille de la résine au endroit où il y a des bulles d'air

Corriger les imperfections de surface à l'aide du sikkens Polysoft selon iG 0043

Laisser sécher jusqu'au lendemain

Quantité: 1

Date: 9-4-10

Sceau: 34



Date: Lundi, 2010-03-15 08:47:39
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



Séq.:

Machine ou Opération:

Description :

39.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le trimage du Pod Base selon le dessin Page 2 de 4 Détail B

Quantité: 1

Date: 13-4-10

Sceau:



40.0

AAC1615

D3001-1 Doubler (Pod Base D2002-3)

1-27006-1

Commentair Qty.: 3 UNITE(s)/Unit Total : 3 UNITE(s)

D3001-1 Doubler (Pod Base D2002-3)

N° de Lot: 1-27006-1

41.0

AAC0103

ARALDITE 2043 (COLLE)

Commentair Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)

ARALDITE 2043 (COLLE)

N° de Lot: 1-26592-1

42.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

À l'aide de l'adhésif Araldite 2043 coller les trois doubler N° D3001-1 selon le dessin & selon IG 0058

Venir faire trois petite poche à vide localisées sur les trois doubliers (Stretchlon 200 seulement pas besoin de perforé, ni de airweave, ni de feutre de drainage, ni de peel ply.)

Laisser sécher pendant 1 heures

Quantité: 1

Date: 9-4-10

Sceau:



43.0

AAC0103

ARALDITE 2043 (COLLE)

Commentair Qty.: 0.50 UNITE(s)/Unit Total : 0.50 UNITE(s)

ARALDITE 2043 (COLLE)

44.0

FINITION

Finition Générale



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirer les trois poches à vide et faire un joint tout autour des trois doubliers à l'aide d'Araldite 2043 et laisser sécher jusqu'au lendemain.

Quantité: 1

Date: 9-4-10

Sceau:



Date: Lundi, 2010-03-15 08:47:39
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: UTILITY POD BASE

Numéro Job: 24910

Numéro Article: DKC134-0015

Numéro Job:



Séq.:

Machine ou Opération:

Description :

45.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.4333 UNITE(s)/Unit Total : 0.4333 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-26006-1

46.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-26575-5

47.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 75.0000Min Total Run : 1.2500Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008



Quantité: 1 Date: 16/04/10 Sceau: 

48.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le sablage au grit 180 de la surface primé pour enlever les imperfections restantes.

Quantité: 1 Date: 20-4-10 Sceau:  

49.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.2217 UNITE(s)/Unit Total : 0.2217 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-26006-1

50.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase


Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-26575-5

51.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer un couche de primer gris N° 7704S selon IG 0008

Quantité: 1 Date: 23/04/10 Sceau: 

52.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire l'inspection dimensionnelle et visuelle de la pièce selon le dessin.

Quantité: 1 Date: 28-4-10 Sceau: 

Date: Lundi, 2010-03-15 08:47:39
Utilisateur: marc dubé

Feuille de Procédé

Cient: DART US DART AEROSPACE LTD
Numéro Job: 24910

Nom Dessin: UTILITY POD BASE
Numéro Article: DKC134-0015

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

53.0

EMBALLAGE

Emballage & Entreposage



Commentair Se'up: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1 Date: 28-04-10 Sceau:



Non-Conformance Report

NCR

102-066

Raised by:

Source:

Source:
QC. Inspection

Sheet No. 1 of 1

Date:

May 13 2010

Priority: HIGH
~~LOW~~

Non-Conforming

Dept./Supplier: Supplier Delastek

Product/Service:

D.2202-1 4-3

0.2694 (350 utility Pool)

Area of Standard:

Section A

QSI

QSP

QSPM

Documents:

P/O 11446

Invoice

	W/O
--	-----

Batch No. 56617

TSR

Drawing D2202

Rev. F.

Root Cause:

Forward to Director, Quality Assurance on completion of Section A

DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion.

Section B

Responsible for Investigation/CA: L. Lacey To be done by: 1006-13

Corrective Action

[illegible]

Fault Category:

Preventive Action Required: NO YES # _____

Section C

Responsible for Verification of CA: _____

Verification of C/A

No	Verification Method	Sign	Date

Forward to DQA on Completion of Verification

DQA: _____

Date: _____

N/C Closed

Date _____

QA Purposes only

N/C Closed

Date _____

Jason Murdoch

From: Céline Audet [caudet@delastek.com]
Sent: Friday, May 14, 2010 9:26 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'; 'Melanie Fauteux'
Subject: RE: NCR10-066/ D2202-1&-3/ p/o11446

RMA# : A-754

Thanks

Céline Audet

Représentante / Representative

De : Jason Murdoch [mailto:jmurdoch@dartaero.com]
Envoyé : 14 mai 2010 09:07
À : 'Céline Audet'
Cc : 'L Lacelle'; 'Melanie Fauteux'
Objet : RE: NCR10-066/ D2202-1&-3/ p/o11446

Hi Celine

Here are the pics of the bottom of the box. As discussed, the top portion of the box has been cut up & sent to the recycling pile. There was no major damage on the top of the box, & the 2 sections of the pod was apparently wrapped quit well in bubble wrap. Is there a Delastek return authorization # that I can reference?

Linda,

Please have the pod sent back to Delastek. I will have Ian place them in the bottom half of the box, that he received it in, & bring to packaging.

Jason Murdoch

Quality Coordinator

jmurdoch@dartaero.com

DART Aerospace Ltd.

613-632-5200

From: Céline Audet [mailto:caudet@delastek.com]
Sent: Friday, May 14, 2010 8:50 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'; 'Melanie Fauteux'
Subject: RE: NCR10-066/ D2202-1&-3/ p/o11446

Hello Jason.

Please return the parts and we will investigate on it on what could happened.

Thank you and have a nice week-end!

Céline Audet

Représentante / Representative

De : Jason Murdoch [mailto:jmurdoch@dartaero.com]
Envoyé : 14 mai 2010 08:23
À : 'Céline Audet'
Cc : 'L Lacelle'; 'Melanie Fauteux'
Objet : RE: NCR10-066/ D2202-1&-3/ p/o11446

Good morning,
Sure thing. There was no damage on the box.

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200

From: Céline Audet [mailto:caudet@delastek.com]
Sent: Friday, May 14, 2010 8:07 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'; 'Melanie Fauteux'
Subject: RE: NCR10-066/ D2202-1&-3/ p/o11446

Hello Jason,

We are working on it, but is it possible to send pictures of the shipping box?

Thank you

Céline Audet
Représentante / Representative

De : Jason Murdoch [mailto:jmurdoch@dartaero.com]
Envoyé : 13 mai 2010 13:33
À : 'Céline Audet'
Cc : 'L Lacelle'; 'Melanie Fauteux'
Objet : NCR10-066/ D2202-1&-3/ p/o11446
Importance : Haute

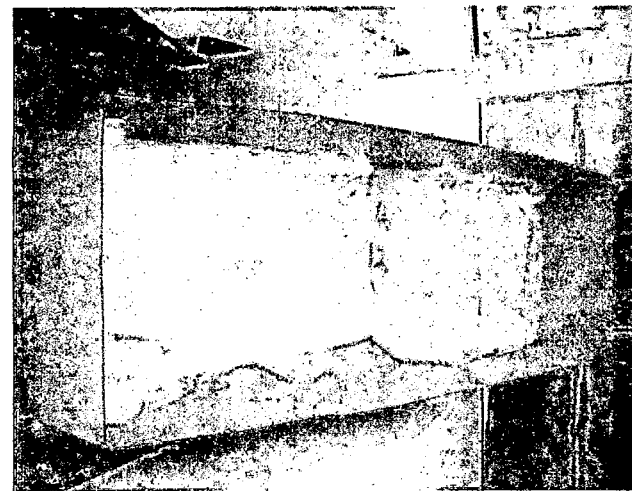
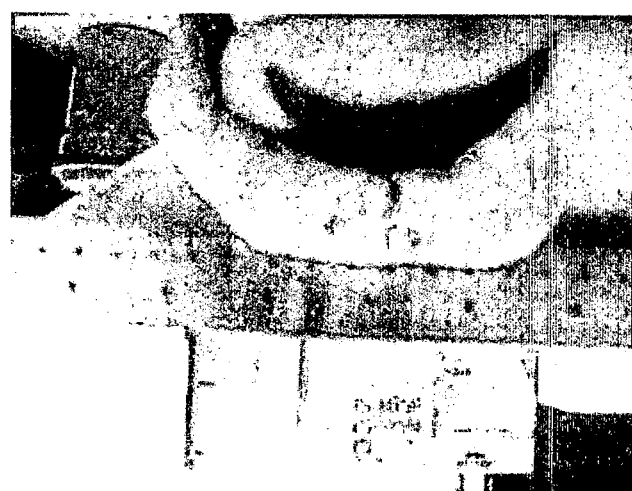
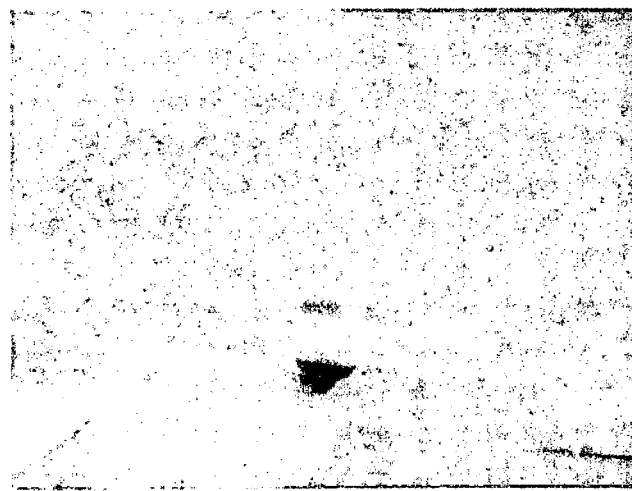
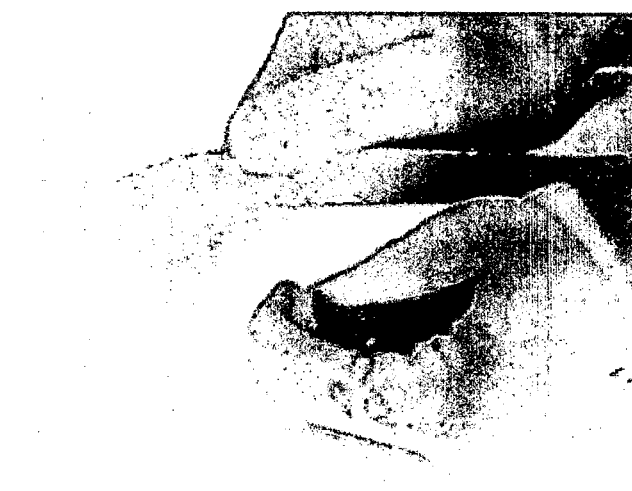
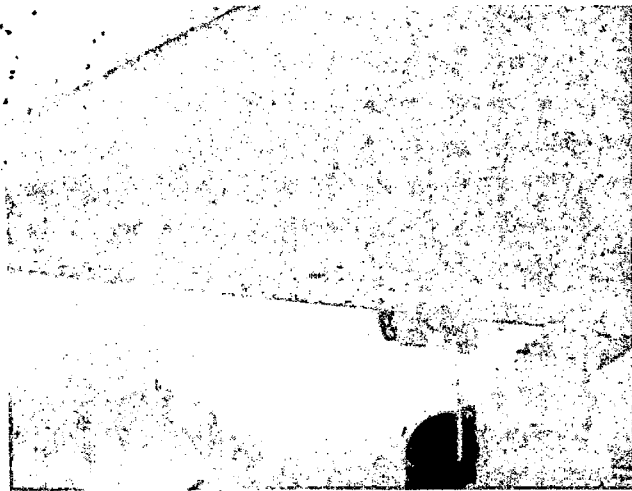
Bonjour Celine,
We received the D2202-1 (Del job # 24909)& -3 (Del job # 24910) on May 10. The receiving inspection was done this morning, and some cracks were found along the edges of both the base & lid. Please see & direct the attached photo's. I would like to have this returned & reworked by Delastek.

This has never been apparent on previous pods, but when the -1 lid is flexed, the inside radius cracks, & snaps along the whole edge. The gel coat chip was already visible & sticking out....that's why we started to mildly flex the edge to see if there were air voids.

On the -3 base, it almost looks like prying marks on one edge near the fwd & aft corners. The gelcoat is cracked around in these 2 area's & one leads into the corner.
If you have any questions, don't hesitate to give me a shout.

Thank you,

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200



Dart Aerospace

[illegible]

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-602 REV E (OR EARLIER REV.)
AND INSTRUCTIONS FOR CONTINUOUS AIRWORTHINESS ICA-D350-602 REV. 0

REF. TCCA STC: SH93-97

REF. FAA STC: SR01144NY

REF. EASA STC: EASA.IM.R.S.01290

PURPOSE

Dart D350-601-011 *Heli-Utility-Pod™* B/N 57243 has new attachment lugs and pod latching configuration as detailed below.

CHANGE

The D2230-1/-3 clamps are replaced with wider D4091-1/D3910-3 lugs. The abrasion strip is replaced with D3984-030 rubber extrusion. The leading/trailing edges of the utility pod each have an additional rubber latch (see Figure 3 of this service instruction). The D2462-1700 Neoprene Seal is replaced with D2461-1700 Neoprene 'D' Seal. The modified parts list for Installation Instruction D350-602 and Instructions for Continued Airworthiness ICA-D350-602 is shown on sheet 2 of this service instruction for the D350-602-011 B/N 57243 only. Install the lugs as shown in Figure 1 & 2 of this service instruction. The pod should otherwise be installed per D350-602 and maintained per ICA-D350-602.

The weight and balance for Dart D350-602-011 *Heli-Utility-Pod™* B/N 57243 is updated as follows:


5.0 WEIGHT AND BALANCE (D350-602 Rev. E)

25.6 WEIGHT AND BALANCE (ICA-D350-602 Rev. 0)

The following weight and balance information is for the Dart *Heli-Utility-Pod™*. The weight and balance of any parts that are removed from the aircraft to perform this installation or equipment installed/stowed in the pods, are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-602-011 B57243	62.7 lb	±51.0 in	±3197.7 in-lb	135 in	8465 in-lb
<i>Heli-Utility-Pod™</i> LH or RH	28.4 kg	±1.29 m	±36.6 m-kg	3.43 m	97.4 m-kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 10.03.30
CERT. NO.: SH93-97
ISSUE NO.: 4

A	NEW ISSUE	CP	10.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	99		
CHECKED	1	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9512	SHEET 1 OF 5
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6.0 PART LIST (D350-602 Rev. E)
25.7 PARTS LIST (ICA-D350-602 Rev. 0)

Qty D350-602 -011	Qty DSI9052 -013	Part Number	Description
X		D350-602-011	HELI-UTILITY-POD™ (FITS BOTH LH/ RH)
	X	DSI9052-013	QUICK RELEASE KIT
1		D2694	POD ASSEMBLY (LH OR RH)
1		*D2202-1	POD LID
1		*D2202-3	POD BASE
7		*D2204-9	LATCH
1		*D2429-041	SPRING CLIP ASSEMBLY
1		*D2461-1700	NEOPRENE 'D' SEAL
7		*D2528-1	BACKER PLATE
6		*D2528-3	BACKER PLATE
1		*D2569	HINGE
1		*D3007-041	PROP ASSEMBLY
1		** D2012-107	CLEVIS
2		** D2022-101	SPACER
1		** D2705	SUPPORT BRACKET
1		** D3007-1	STRUT
1		** D3015-3	LOCKNUT
1		** AN4-10A	BOLT
1		** AN960JD416	WASHER
1		** MS21042L4	NUT (OR MS21042-4)
1		** SL69-BS	BALL STUD
1		** AN960JD516	WASHER
27		*AN4-5A	BOLT
1		*AN4-6A	BOLT
2		*AN526C632R7	SCREW
29		*AN960JD416	WASHER
2		*AN960JD6	WASHER
2		*MS21042L06	NUT (OR MS21042-06)
28		*MS21042L4	NUT (OR MS21042-4)
4		D4091-1	LUG
4		D3910-3	LUG
1		D2258-160	LABEL
1		D2324-1	STRUT ASSEMBLY
2		D2523	MOUNTING BRACKET
2		D2524	SIDE PLATE
8		D3984-030	RUBBER EXTRUSION
1		D3495-1	PLACARD
4		AN3-7A	BOLT
8		AN3-15A	BOLT
1		AN4-12A	BOLT
16		AN4-14A	BOLT
4		AN4-16A	BOLT
24		AN960JD10	WASHER
42		AN960JD416	WASHER
12		MS21042L3	NUT (OR MS21042-3)
21		MS21042L4	NUT (OR MS21042-4)
	1	BLRS-010	QUICK RELEASE PIN (1" GRIP)
	3	BLRS-020	QUICK RELEASE PIN (1.5" GRIP)

* INCLUDED IN D2694 OR D3322-041/-042 POD ASSEMBLIES LISTED ABOVE



** INCLUDED IN D3007-041 PROP ASSEMBLY LISTED ABOVE

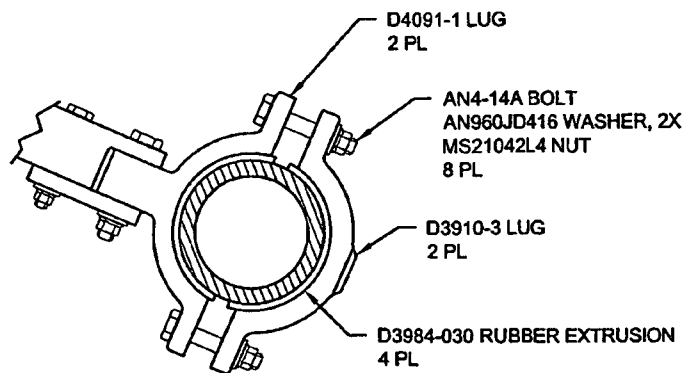
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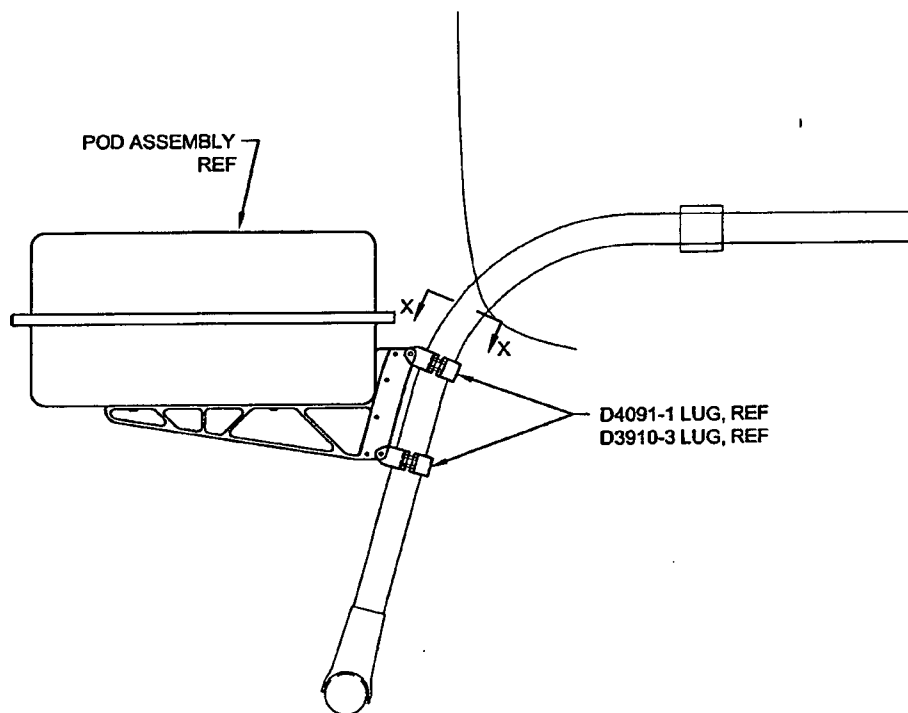
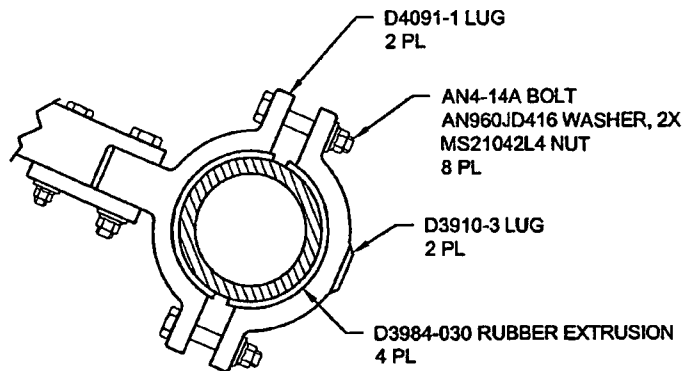


FIGURE 1: Aft Crosstube Attachment
(Installation of D4091-1 / D3910-3 Lugs)

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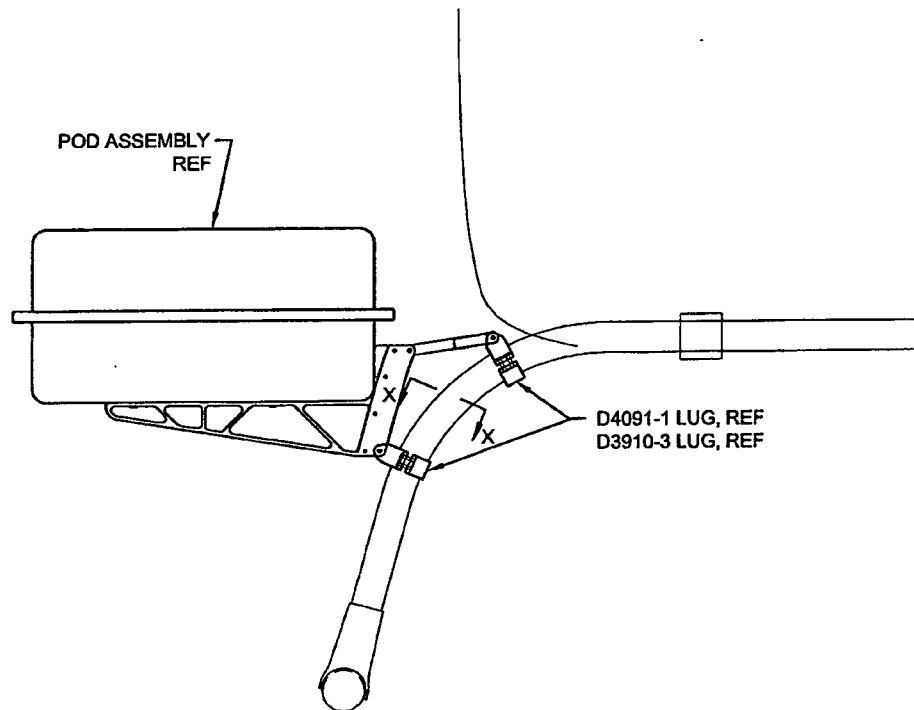


FIGURE 2: Fwd Crosstube Attachment
(Installation of D4091-1 / D3910-3 Lugs)

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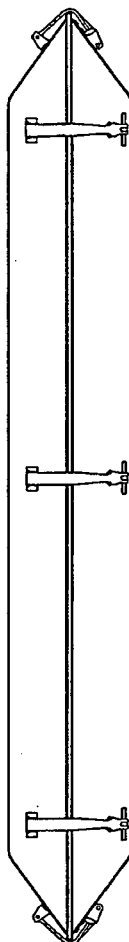
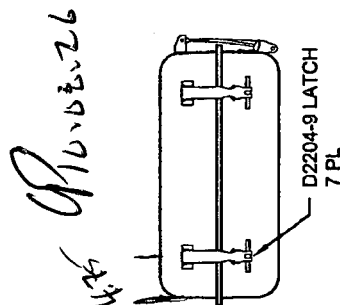


FIGURE 3: Pod Detail
(D350-602-011 B/N 57243)



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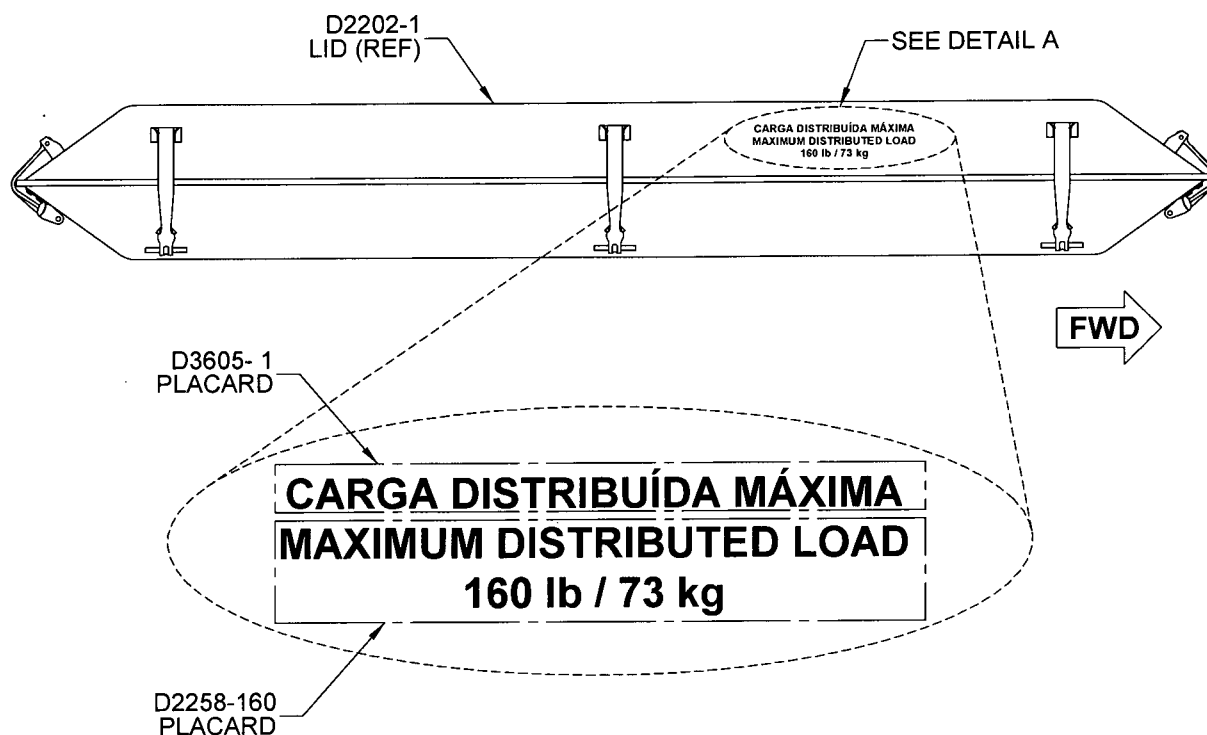
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ISSUE NO.: 4

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
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APPROVED	<i>[Signature]</i>	TITLE	SCALE
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DART SERVICE INSTRUCTION

When the D350-602-XXX Heli-Utility Pods are installed on a Brazilian registered aircraft, install the D3605-1 Placard above the D2258-160 Placard located on the D2202-1 Lid of the Heli-Utility Pod as follows:

1. Saturate a clean cotton cloth with 4105S Wash 'n' Wipe Degreaser or MEK (or equivalent) and wipe the surface to clean the entire area.
2. If necessary, touch up finish in accordance with ICA-D350-602.
3. Install D3605-1 Placard per Figure 1 using a 3M PA-1 Plastic Applicator (or equivalent) to blend out blisters as required.



DETAIL A: INSTALLATION OF D3605-1 PLACARD

FIGURE 1: D350-602-XXX HELI-UTILITY POD
(RH SHOWN, LH SIMILAR)

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CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9388	SHEET 1 OF 1
APPROVED	<i>LB</i>	TITLE	SCALE
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